

Work Order ID 61926-2

PRELIMINARY ISSUE

Thursday, September 09, 2010 12:54:48 PM

Page 1

Item ID: D4180-5

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date: 10-9-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4180	PA1								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: PA1 Prog Rev: PA1								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

1B10-4-13

(4)

1B10-4-13

Work Order ID 61926

Thursday, September 09, 2010 12:54:48 PM



Page 3

Item ID: D4180-5

Accept



Setup Start



Revision ID: PRELIM

Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

10/09/16

x4

0

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

BR 10-9-16

4

0

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Memo

composites

1 2 3 2

ST 10-10-01 (x3)

Work Order ID 61926

Thursday, September 09, 2010 12:54:48 PM



Page 4

Item ID: D4180-5

Accept



Setup Start



Revision ID: PRELIM

Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/04 AJ
12-10-10-01
(3)

POSITIVE RECALL

EFFECTIVE 10/9/09 AUTH 1

RELEASED 10/9/09 DATE 10/09/09

952 Release DW5
DATE 10.09.29

Picklist Print

Thursday, September 09, 2010 12:54:52 PM

Page 1

Work Order ID: 61926

Parent Item: D4180-5

Parent Item Name: Gusset



Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	125.2600	0.0989	0.208211			



6061-T6.125 Sheet



1310-4-13

Location

Loc Qty

Loc Code

MAT21

125.26

113608

96

114352

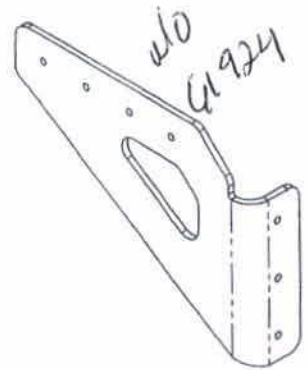
29.26

114352

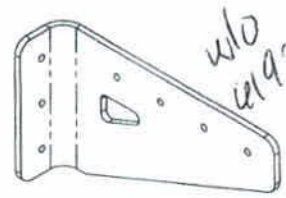
(4)

Route / Born / Ax F
 → DONE ←

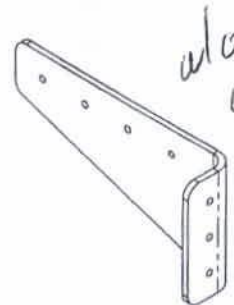
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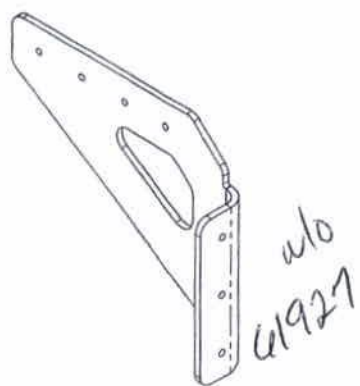
D4180-1 GUSSET



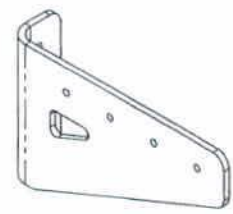
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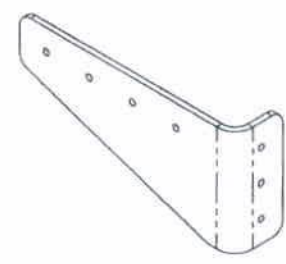
D4180-5 GUSSET



D4180-2 GUSSET



D4180-4 GUSSET



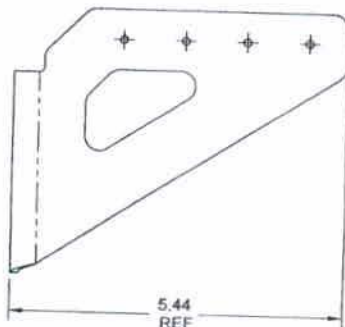
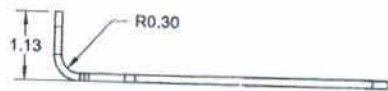
D4180-6 GUSSET

SHOULD BE
 REVISION 1
 DRAFT
 UNCONTROLLED
 SUBJECT TO APPROVAL
 DATE 10-09-09
 41929
 PL 10-9-09

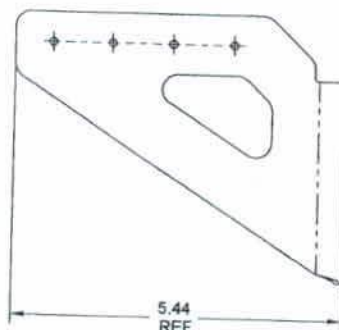
PRELIMINARY ISSUE
 10.09.08

PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

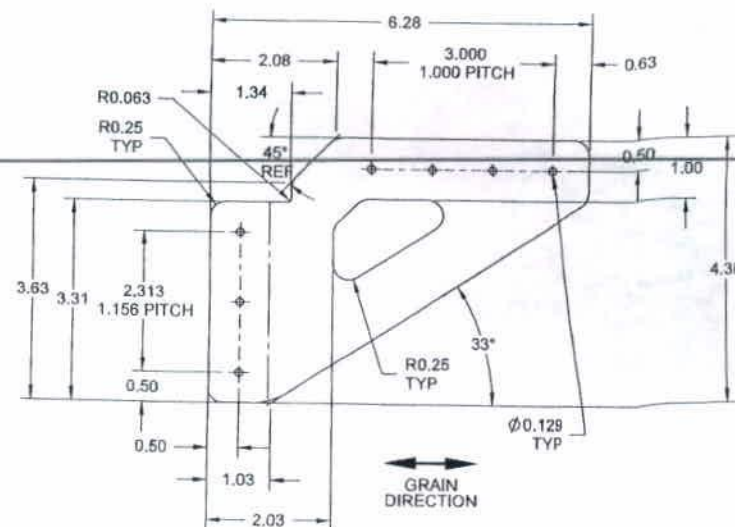
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4180	REV. PA1 SHEET 1 OF 4
TITLE POD FRAME GUSSETS	
SCALE NTS	
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D4180-2 GUSSET
MAKE FROM D4180-TF



D4180-1 GUSSET
MAKE FROM D4180-TF



D4180-1F GUSSET FLAT PATTERN

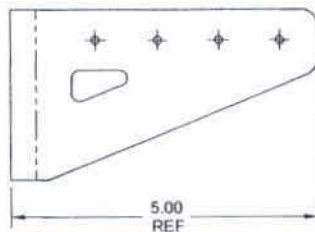
PRELIMINARY ISSUE
10.09.08

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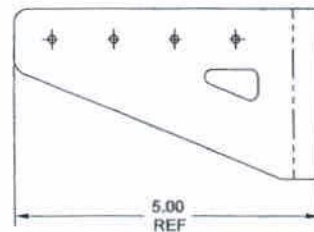
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA1
MFG. APPR.		D4180 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		POD FRAME GUSSETS NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD

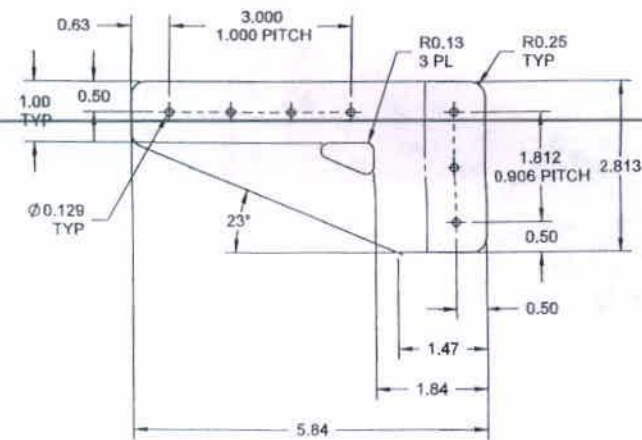
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D4180-4 GUSSET
MAKE FROM D4180-3F



D4180-3 GUSSET
MAKE FROM D4180-3F



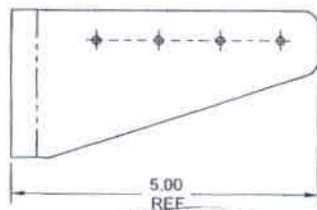
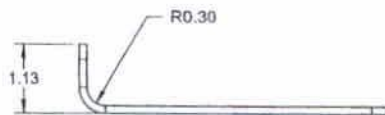
D4180-3F GUSSET FLAT PATTERN

PRELIMINARY ISSUE
10.09.08

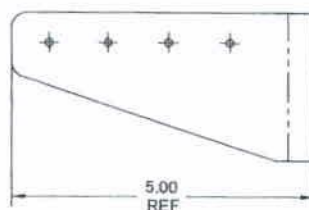
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs EACH

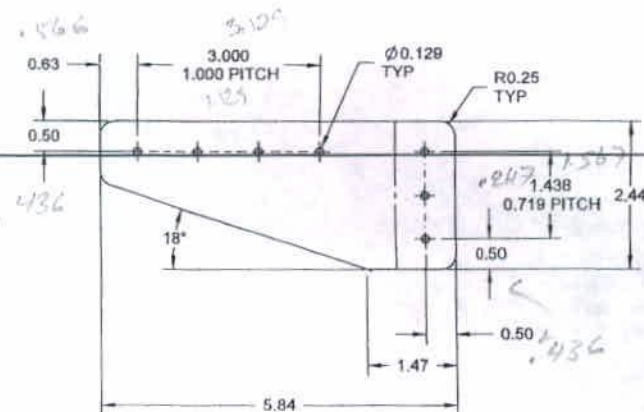
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D4180-5 GUSSET
MAKE FROM D4180-5F



D4180-6 GUSSET
MAKE FROM D4180-5F



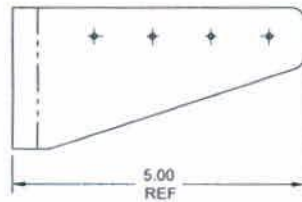
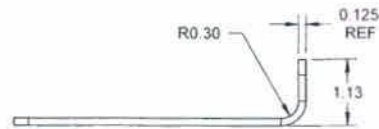
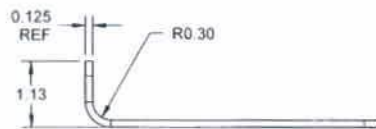
D4180-5F GUSSET FLAT PATTERN

PRELIMINARY ISSUE
10.09.08

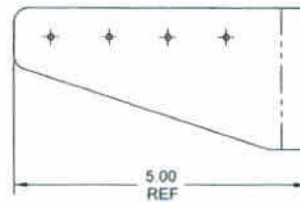
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

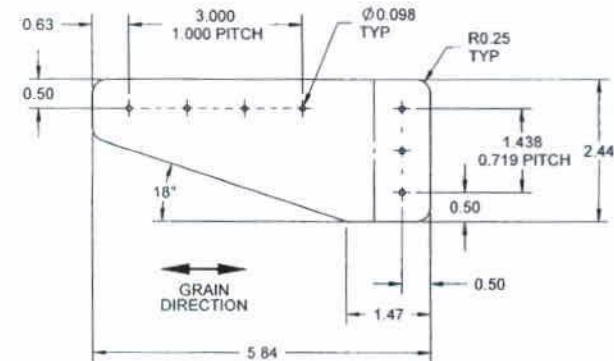
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CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 4 OF 4
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D4180-5 GUSSET
MAKE FROM D4180-5F



D4180-6 GUSSET
MAKE FROM D4180-5F



D4180-5F GUSSET FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	J	D4180	SHEET 4 OF 4
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RELEASED
2010-09-29

61926